

Date: Wednesday, 1/23/2008 11:32:07 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : AFT BASE ASS'Y

Job Number : 36913

Estimate Number : 13043

P.O. Number :

This Issue : 1/23/2008 S.O. No. :

Prsht Rev. : NC

First Issue : / / Type : SMALL /MED FAB

Previous Run : 35850

Written By :

Checked &amp; Approved By :

Comment : Est Rev:A New Issue 07-09-27 DD verified by:

Est Rev:B ECN 1113P 08-01-22 DD

Part Number : D3651041

Drawing Number : D3651 REV.B U/R

Project Number : N/A

Drawing Revision : B U/R

Material :

Due Date : 2/29/2008

Qty:

06.03.13



Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

2.0

D3651043

FLANGE ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

FLANGE ASSEMBLY

3742  
B13032

3.0

D36511

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

B37137

4.0

D36519

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

DOUBLER

B37138

5.0

D365111

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

B37139

6.0

D365113

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

DOUBLER

B37140

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: 12 Date: 08/03/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: AFT BASE ASS'Y

Job Number: 36913

Part Number: D3651041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

CR3523402

RIVET



Comment: Qty.: 58.0000 Each(s)/Unit Total : 116.0000 Each(s)  
RIVET

M106302

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: 1-Assemble as per dwg D3651  
2- Seal all mating surfaces and gaps using Proseal 700 fire wall sealant as per dwg D3651  
Batch: M106294  
3-install D3651-1 using 3M high performance contact adhesive 1357 as per dwg D3651  
Batch: M105623

080313

(1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING  
APPROVAL

08.03.10

08/03/14 (40)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock  
Location: PPP 38103

08/03/18 (1)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

080318

Job Completion



POSITIVE RECALL

EFFECTIVE 08.03.14

AUTH U

RELEASED 08.03.13

DATE 08.03.13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

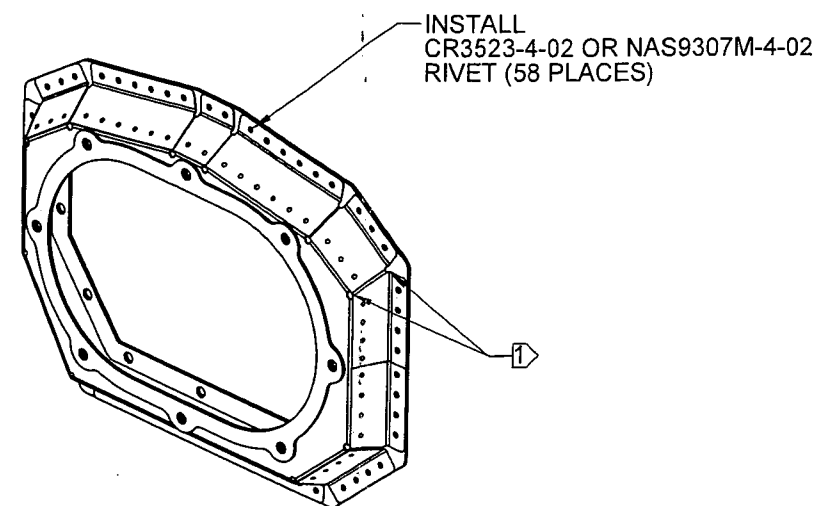
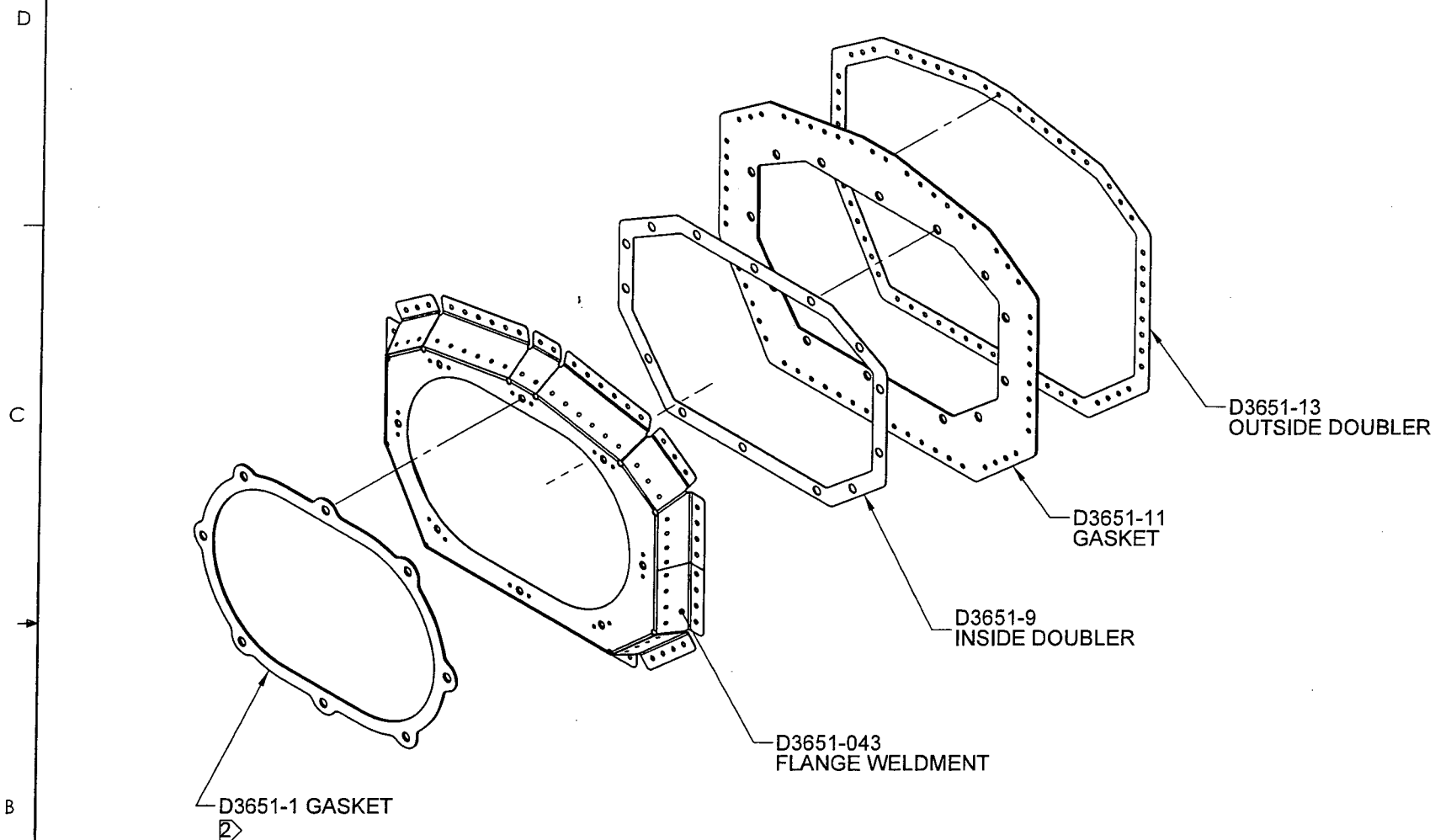
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## PART LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

**D3651-041 AFT BASE ASSEMBLY****PRELIMINARY ISSUE**

LE 08.01.07

**D3651-041 NOTES:**

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	AD	D3651	SHEET 1 OF 9
APPROVED	AD	TITLE	SCALE
DE APPR.		AFT BASE ASSEMBLY	1:4
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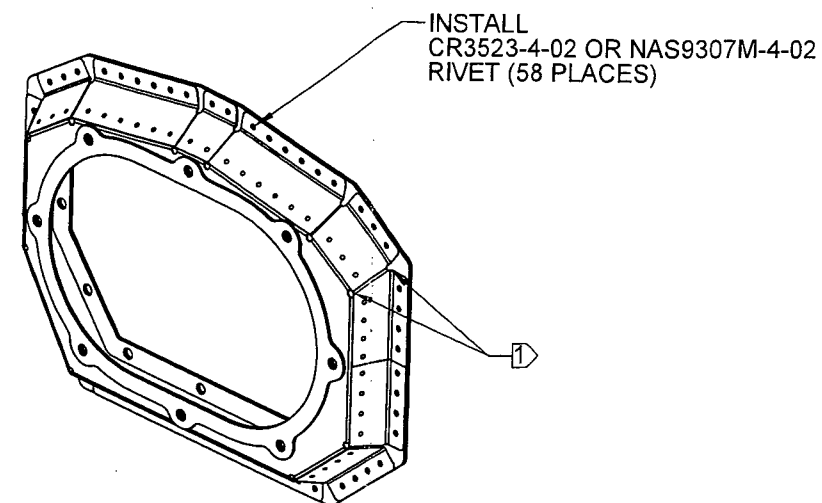
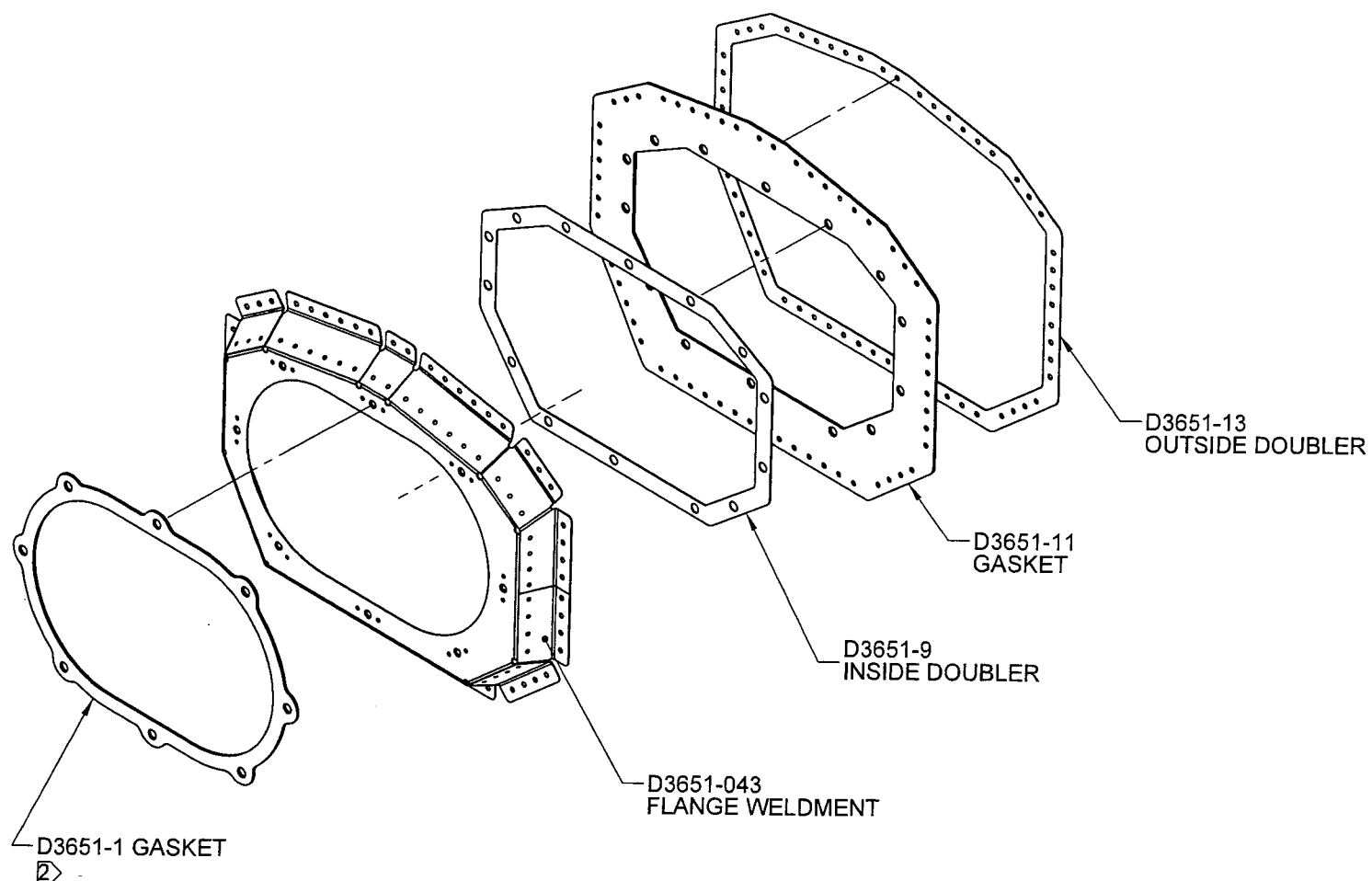
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